

Date: Wednesday, 19/11/2008 2:16:48 PM
 User: Julie Dawson

Process Sheet

| | | | | | | | |
|-----------------------|---------------------------------------|--|--|------------------|------------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : DOOR ASSEMBLY | | |
| Job Number | : 43553 | | | Part Number | : D32131 | | |
| Estimate Number | : 10711 | | | Drawing Number | : D3213 REV A | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 19/11/2008 S.O. No. : | | | Drawing Revision | : A | | |
| Prsh Rev. | : NC | | | Material | : | | |
| First Issue | : / / Type : SMALL /MED FAB | | | Due Date | : 28/11/2008 Qty: 10 Um: Each | | |
| Previous Run | : 42104 | | | Comment | : Est Rev:A New Issue 05-11-17 JLM | | |
| Written By | : | | | Est Rev:B | Now on Waterjet 07-02-13 JLM | | |
| Checked & Approved By | : <u>JLD 08-11-19</u> | | | | | | |
| Comment | : | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet | |
| | | Comment: Qty.: 0.4950 sf(s)/Unit Total : 4.9497 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3213-1 Batch: <u>109463 HB 8-11-24</u> | (10) |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | Comment: FLOW WATER JET | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | HB 8-11-24 | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | | |
| | | Comment: SECOND CHECK | S 08/11/24 (10) |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr HB 8-11-24 | (10) |
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 | |
| | | Comment: HAND-FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 | HB 08/11/25 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 2:16:48 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43553

Part Number: D32131

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 180

AS 08/11/28 (10)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 43553 |
| Description: Door Panel | Part Number: | D3213-1 |
| Inspection Dwg: D3213 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | |
|------------------------|-----------------------|-------------------------|
| Measured by: <u>BS</u> | Audited by: <u>C</u> | Prototype Approval: N/A |
| Date: <u>08-11-24</u> | Date: <u>08/11/24</u> | Date: N/A |

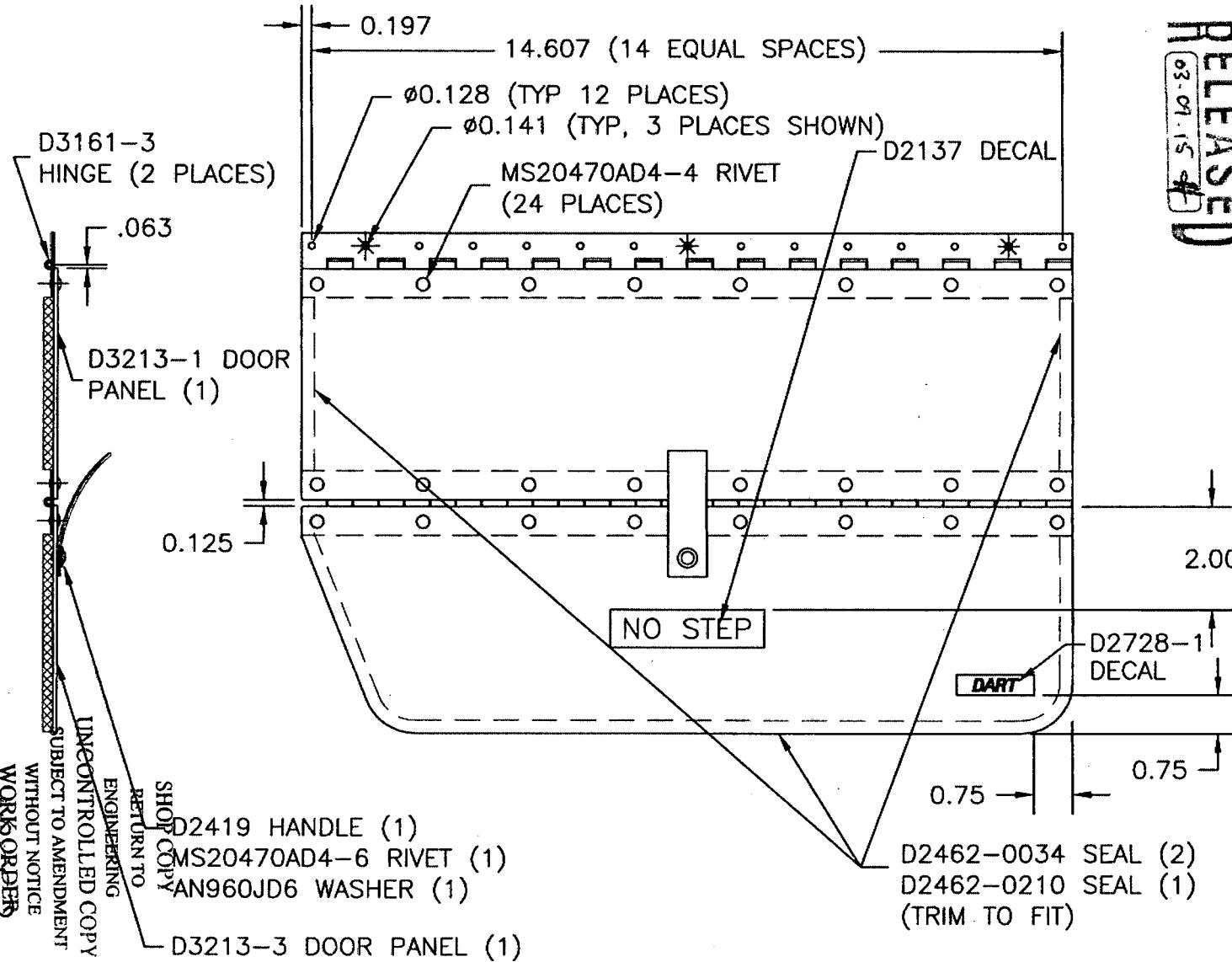
| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|----------------------------|-------------------------|
| A | 03.12.15 | New Issue | P/O D350-567-015/-025/-031 | KJ/RF <i>[initials]</i> |

RELEASED
03.09.03 #

DART



| | | |
|------------------|------------------------|---------------------------------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3213 |
| DATE 03.09.03 | TITLE DOOR ASSEMBLY | REV. A 1 OF 2 SCALE 1:3 |



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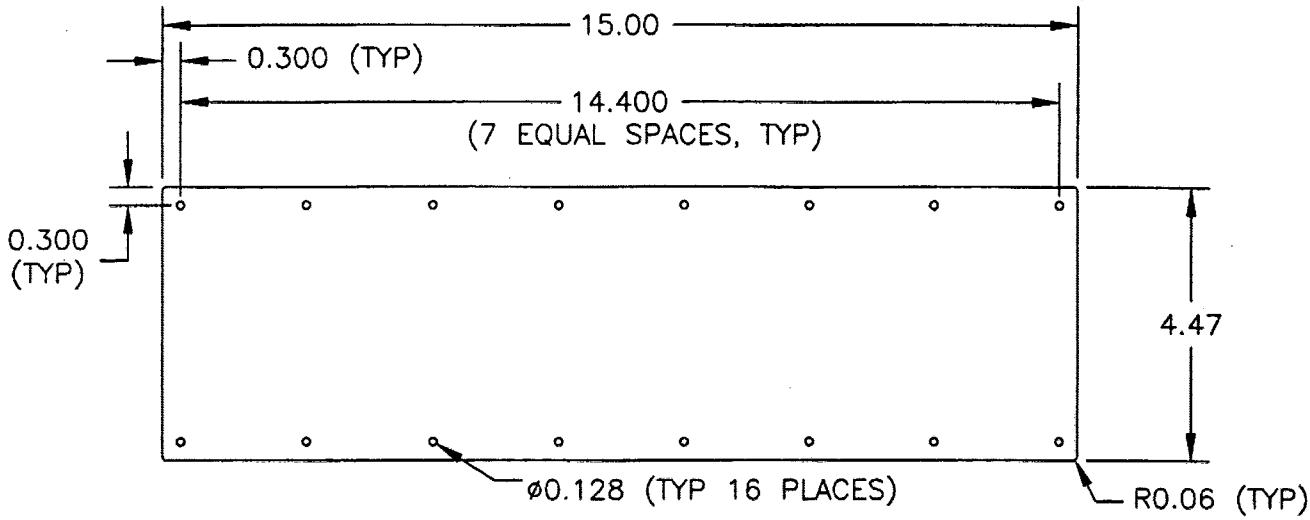
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WORKERS

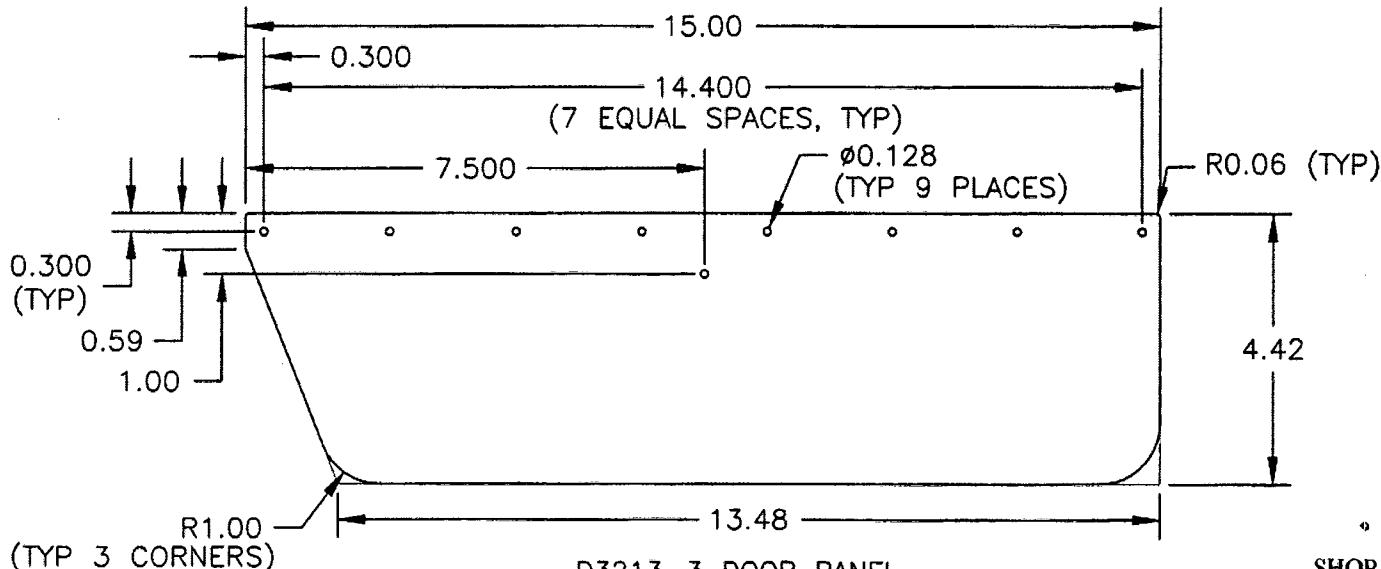


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| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3213 REV. A 2 OF 2 |
| DATE 03.09.03 | | TITLE DOOR ASSEMBLY SCALE 1:3 |



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 43583